

Work Order ID 57771

April 14, 2010 1:52:53 PM



Page 1

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 14/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 20/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

SAD 10-04-20

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: 111679

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

②

[Signature] 10-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

② PD 10.04.21

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.06.04/21

② x2

-042

150

Identify as per dwg & Stock Location: U.P

0.00



Packaging

Memo

0.00

Packaging

SAP
10-04-22

②

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/23 *[Signature]*

MF
10-4-22

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 1:53:31 PM

Page 1

Work Order ID: 57771

Parent Item: D3852-042

Parent Item Name: Rib Assembly


Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Start Date: 14/04/2010

Required Date: 20/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-3  Basket Hoop		Manufactured	No			100	Each	12.2238	0.3789			

SAD 10-04-20

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

12.22380526

55697

0.22380526

56426

6

57504

6

0.3789

D3759-1



Bushing

Manufactured No

100 Each

57.0000 2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

57

54072

9

57184

12

57595

36

~~10-04-20~~
Cpl 10-04-20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

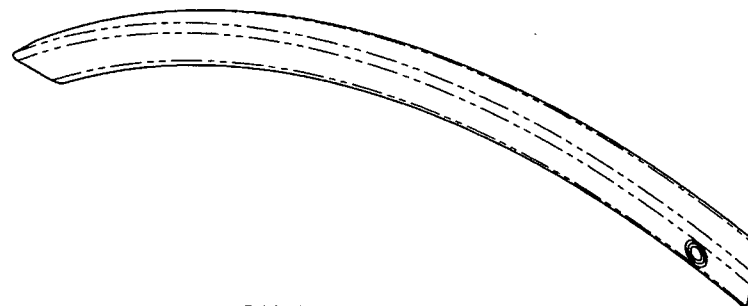
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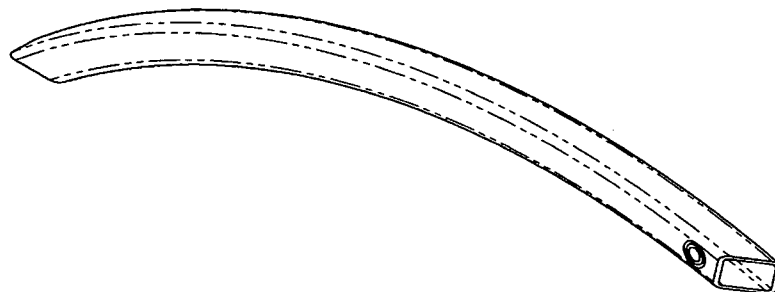
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57771
BS 10-4-14

RELEASE
08/11/08 MPD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

REV.	NEW ISSUE	DESCRIPTION	MB	08.11.07
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.11.07			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
TITLE **RIB ASSEMBLY** SCALE NTS

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8 7 6 5 4 3 2 1

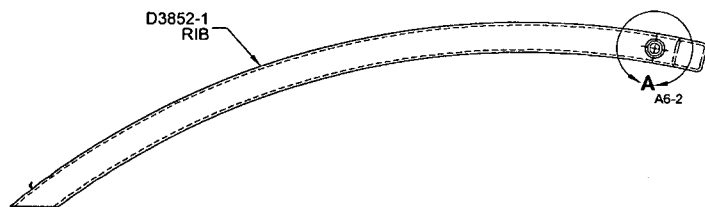
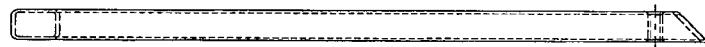
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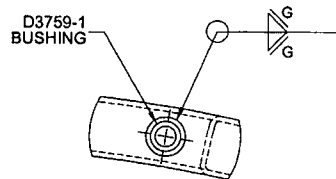
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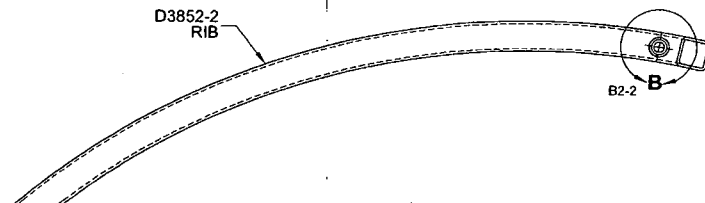
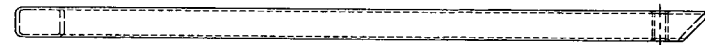
NOTE: Date & initial all entries



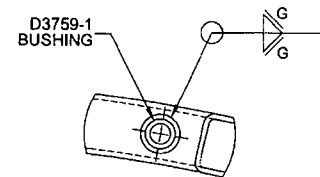
D3852-041 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2



D3852-042 RIB ASSEMBLY



DETAIL B
SCALE 2X C2-2

w/o 57771

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>125</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AD</i>	D3852	SHEET 2 OF 3
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	RIB ASSEMBLY	NTS
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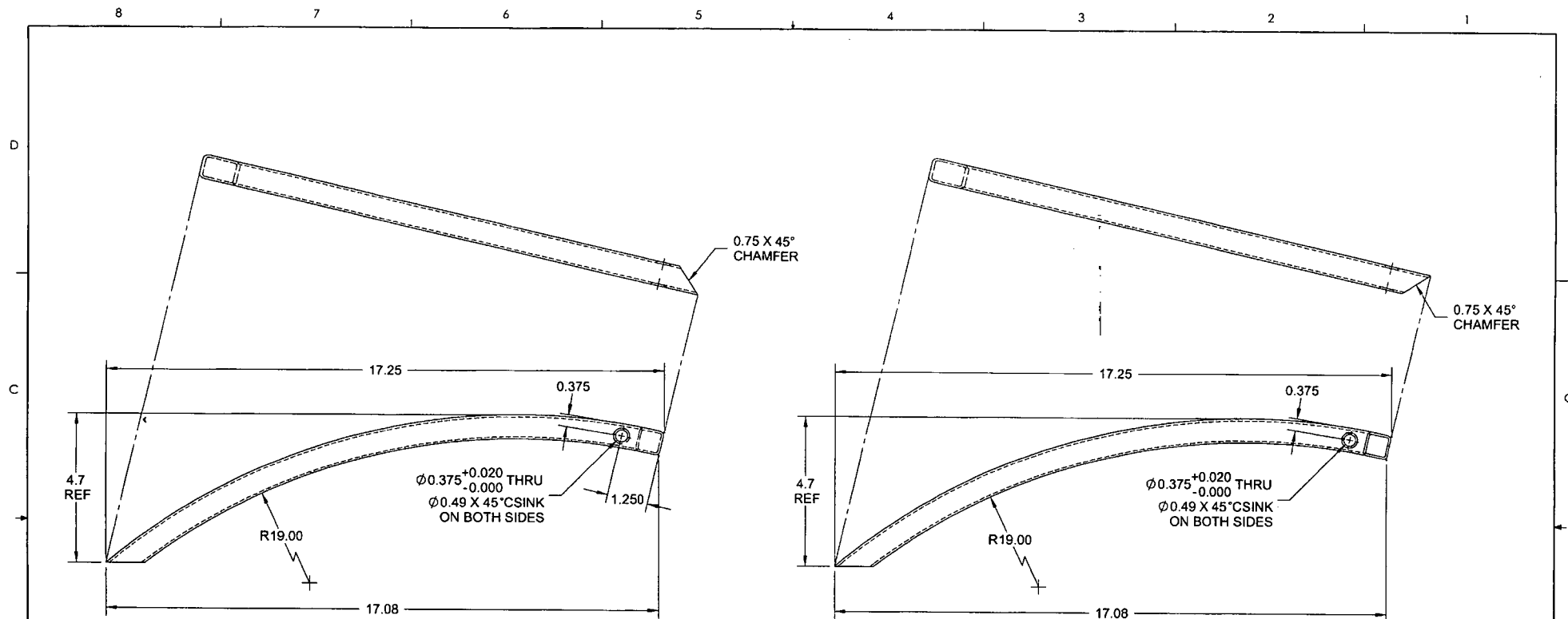
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D3852-1 RIB

D3852-2 RIB

W/057771

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3852	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
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